

Date: Monday, 3/6/2006 1:51:39 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY RH
 Job Number : 26064
 Estimate Number : 10799
 P.O. Number : N/A Part Number : D350600142
 This Issue : 3/6/2006 S.O. No. : N/A Drawing Number : D3187 REV A/ICA-D350-600
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A/2 06.03.07
 Previous Run : 25302 Material :
 Due Date : 3/31/2006 Qty: 1 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.03.06*
 Comment : Est Rev:D 05/04/14 Incorporated procedures from D3187-1/-2 K J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-142 CHG002

KS 06.03.07

①

2.0 26064A SPACEPOD BODY RH



Comment: Sub-Component SPACEPOD BODY RH

3.0 26064B SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR RH

4.0 D31872 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-2 Floor *B 25405*1 D3186-2 DOOR (REF) *B 26064B*1 D3188-2 BODY (REF) *B 26064A**m 06/06/14*

5.0 ALS41032130 Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 ALS4-1032-130 Insert *M 18293*

✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-2. Open holes in floor to Ø0.297". Install inserts as per Dwg D3188.

ml 06/06/14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.06.14

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3187-2 as per Dwg 3187

2-Deburr D3187-2

ml 06/06/14

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.06.14

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-07-04

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-07-04

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

W/O:		WORK ORDER CHANGES						
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Job Number: 26064

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.62SF D2986

Neoprene Foam

B246 28

✓

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1 ml

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M16194

SAD 06:07:04

✓

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2607.4

16.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2179 Hinge Bracket Plate

B21420

✓

17.0

D2219

Door Prop Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2219 Door Support Bracket

B14027

✓

18.0

D2228

Backing Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2228 Backing Plate

B24560

✓

19.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 D2237 Strike Plate

B25327

✓

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2464

3/4 Seal



Comment: Qty.: 10.9305 f(s)/Unit Total : 10.9305 f(s)

Pick:

Qty Part Number Description Batch

1 D2464-125" neoprene Seal

B25153

21.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2586 Latch

B26079

22.0

D2588

Bracket mounting channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2586 Latch

1X D2588

B21509

23.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2588 Mounting Channel

1X D2589

B26031

24.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2621 Latch Plate

B25474

25.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-1 Hinge Bracket

B26501

These are mixed

W/O:		WORK ORDER CHANGES						
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Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-2 Hinge Bracket B26034

✓

27.0

D2977

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2977 Hinge Bracket B14106

✓

28.0

D2978

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2978 Hinge Bracket B14107

✓

29.0

D2982041

Prop Arm Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2982-041 Prop Arm Assembly B24627

✓

30.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock Nut B22365

4.66

✓

31.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 A3235-020-935 Washer M100477

✓

W/O:		WORK ORDER CHANGES							
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Job Number: 26064

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN526C832R9

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN526C832R9 Screw M100447

33.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M100743

34.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer M15927

35.0

AN960JD8

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 AN960JD8 Washer M11989

36.0

AN960JD8L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD8L Washer M6956

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26064

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS20426AD45

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batc

6 MS20426AD4-5 Rivet M3459

38.0

MS21042L08

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

14 MS21042L08 Nut (or -8) M100564

39.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS21042L3 Nut (or -3) M15539

40.0

MS270390810

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0810 Screw M5865

41.0

MS27039125

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS27039-1-25 Screw M17570

42.0

SL69BS

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 SL69-BS Ball Stud M16948

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
04/06/12	37.0	Permanent change: add in Pick list 2x Rivets MS20426-AD4-6 <u>MS566</u> They missing.	<u>ml</u> XXXXXXXXXX		2				
		These rivets are not in the system or Dwg E 0607.13			DWG/ICA CURRENTLY UNDER REVIEW DSL TO FOLLOW.		OK TO COME 3 06.07.13		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LA Date: 06/07/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 26064

Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

ml 06/06/14

PTO

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188-2 & QSI 005 4.4

Batch:

m101266

MA 06 27 (V)

45.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

060704

46.0

K10018

Spacepod Hardware Kit



Comment: Qty: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

B26013

1 D3187-2(Ref)

Spacepod Floor

B26905

47.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/07/11 (1)

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142

Location:

PPP Rev:

c

06/07/11 (1)

49.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/12 (1)
06.07.12

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/06/14	431	Qc5 → by <i>[Signature]</i> 06-07-10 Add This to estimate permanent change <i>[Signature]</i>	<i>[Signature]</i>	06-07-13			<i>[Signature]</i> 06-06-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section B	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/06/14	430	The door and the body don't fit well. Have to grind some places Use glue <u>M100008</u> and primer <u>M109111</u> <i>[Signature]</i>		Sanded door edge smooth to conform to body for better fit. Seal edge with '9100' primer B#5 <i>[Signature]</i>		<i>[Signature]</i> 06-06-14		<i>[Signature]</i> 06-06-14

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. A SHEET 1 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	

RELEASED
03.04.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1	DT8003	DT8501
D3188-2	DT8004	DT8502
D3188-3	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26064

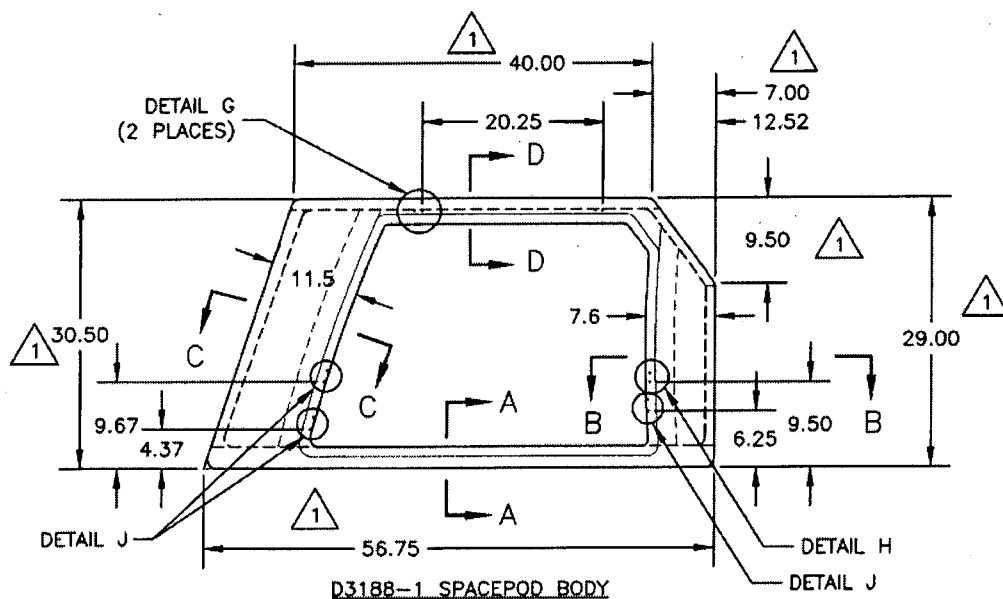
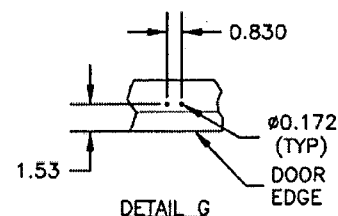
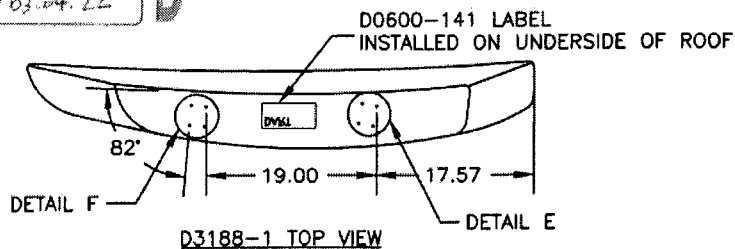
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DESIGN JB	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. A SHEET 2 OF 7
DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
03.04.22



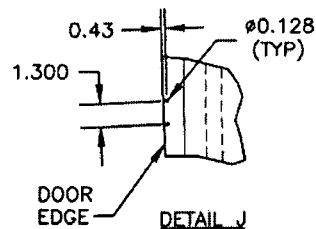
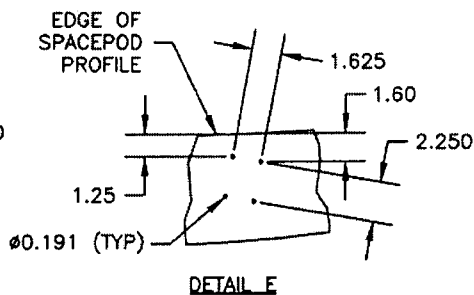
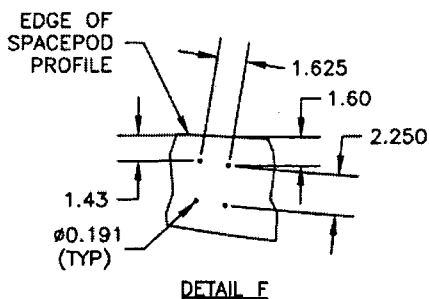
0.50

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(TYP)

1.000

DOOR
EDGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26064



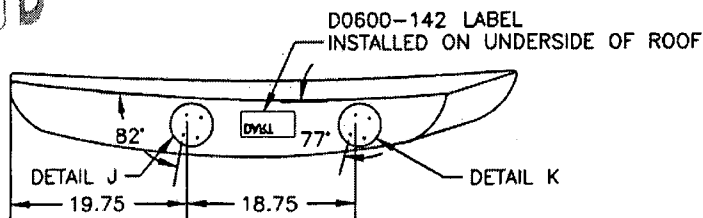
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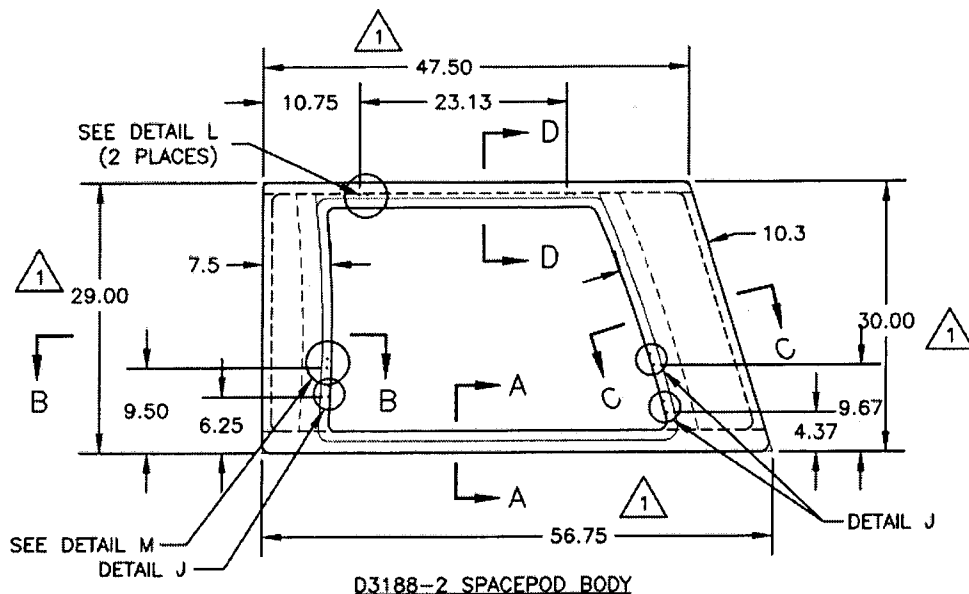


DESIGN JB	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. A SHEET 3 OF 7
DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

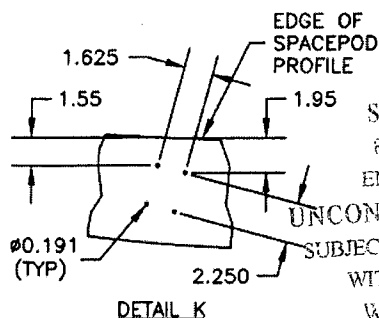
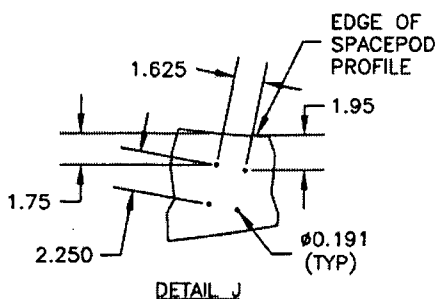
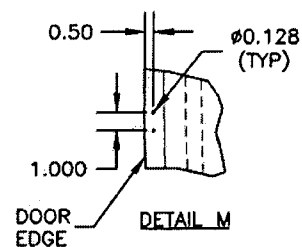
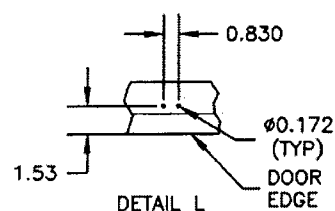
RELEASED
03.04.22



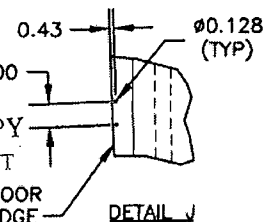
D3188-2 TOP VIEW



D3188-2 SPACEPOD BODY



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26064



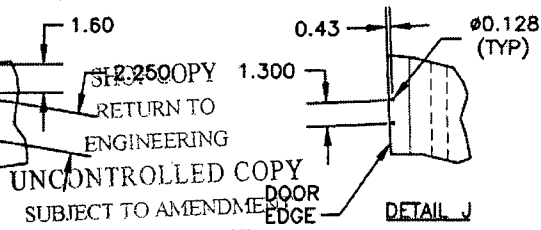
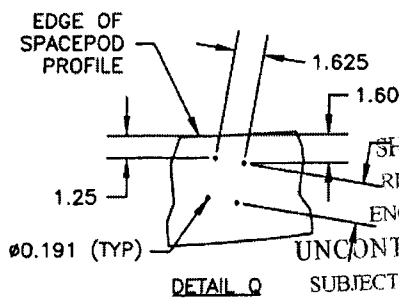
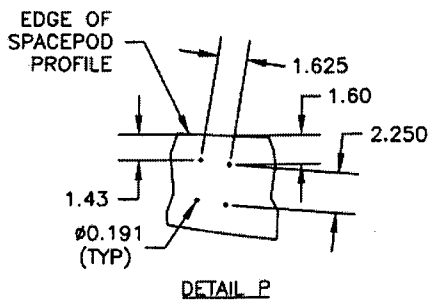
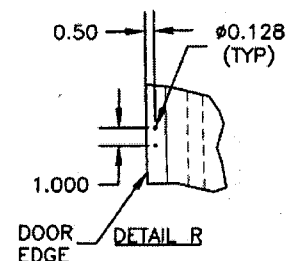
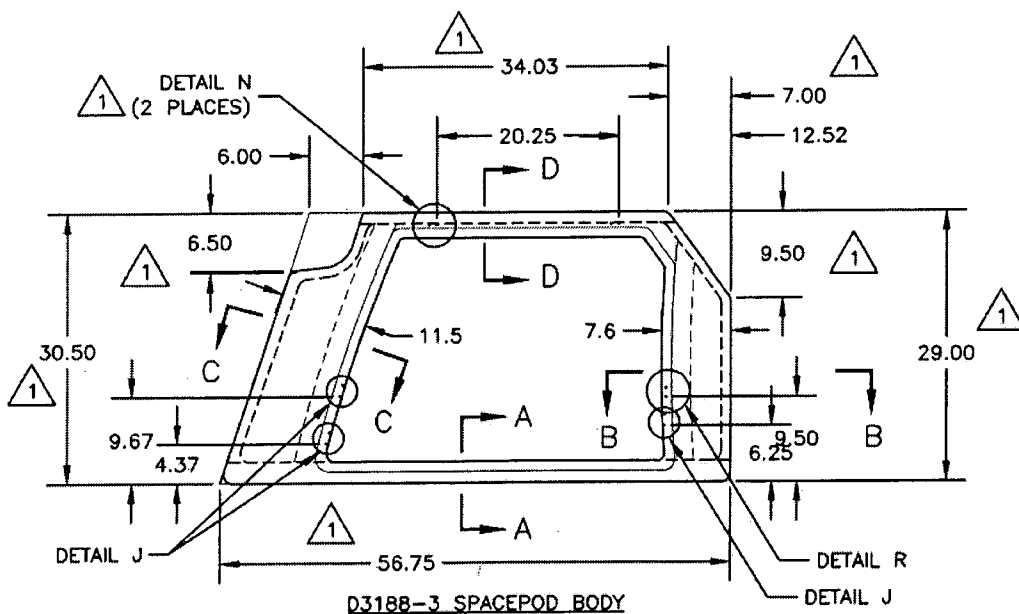
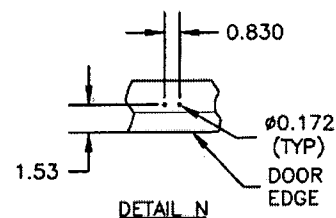
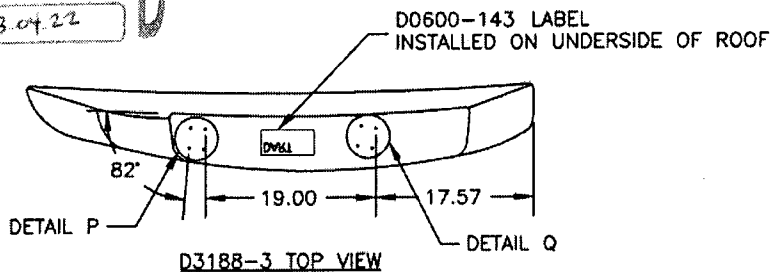
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. A SHEET 4 OF 7
DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

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03.04.22



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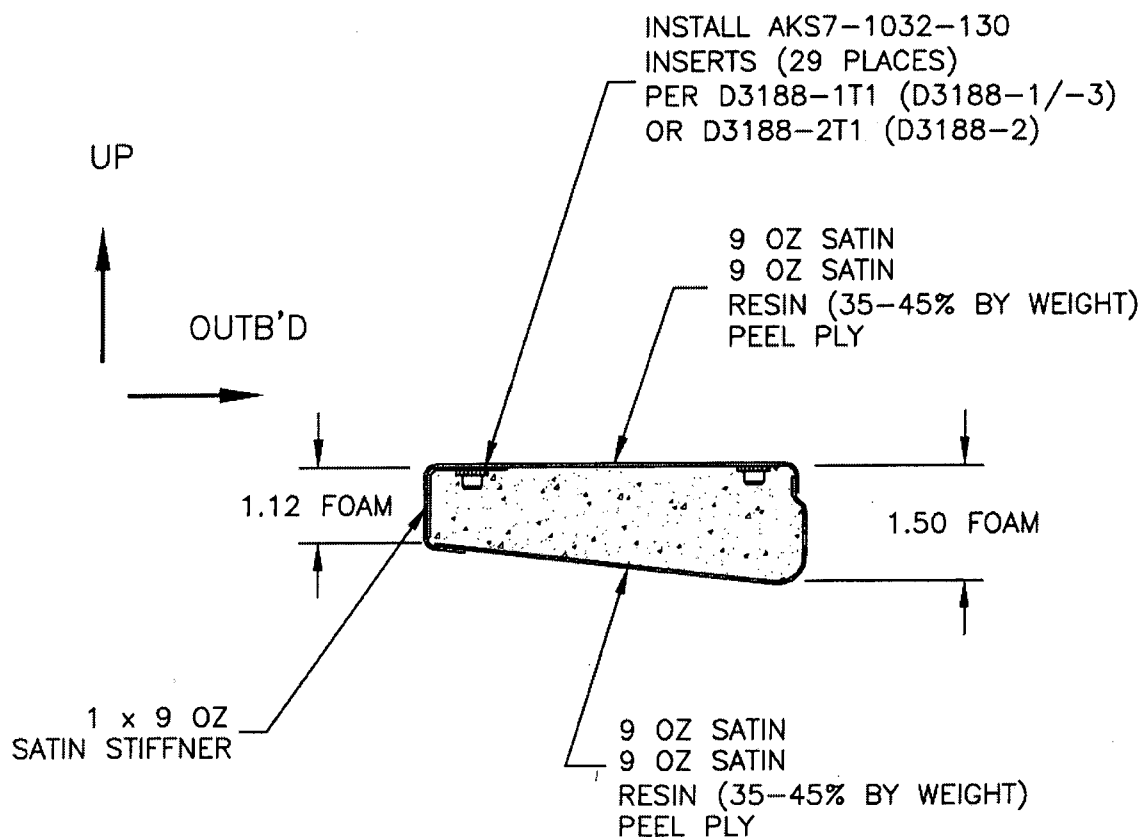
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DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

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SECTION A-A
(TYPICAL FLOOR SECTION)

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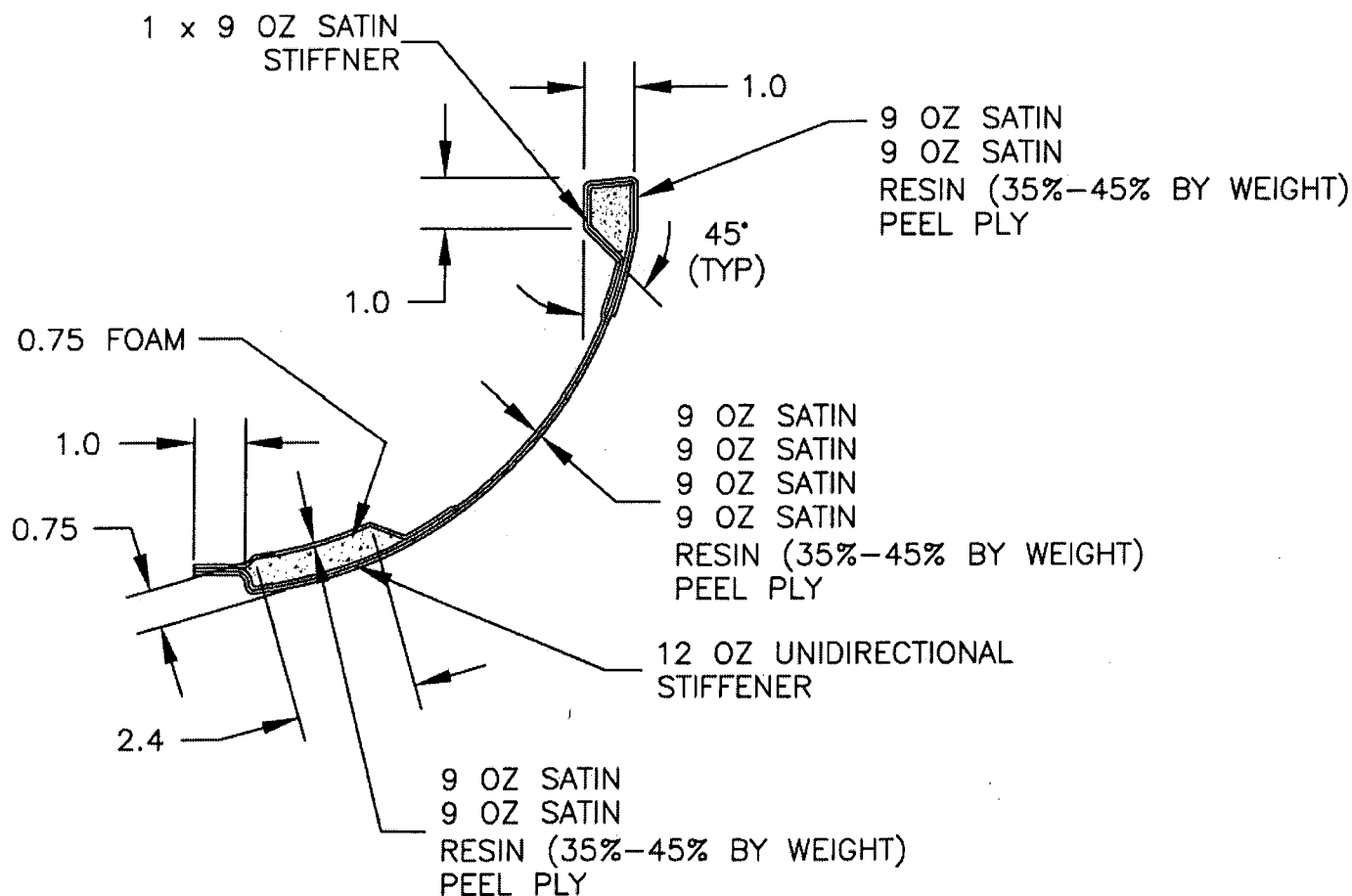
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DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

03.04.28
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SECTION B-B
(SECTION C-C SIMILAR)

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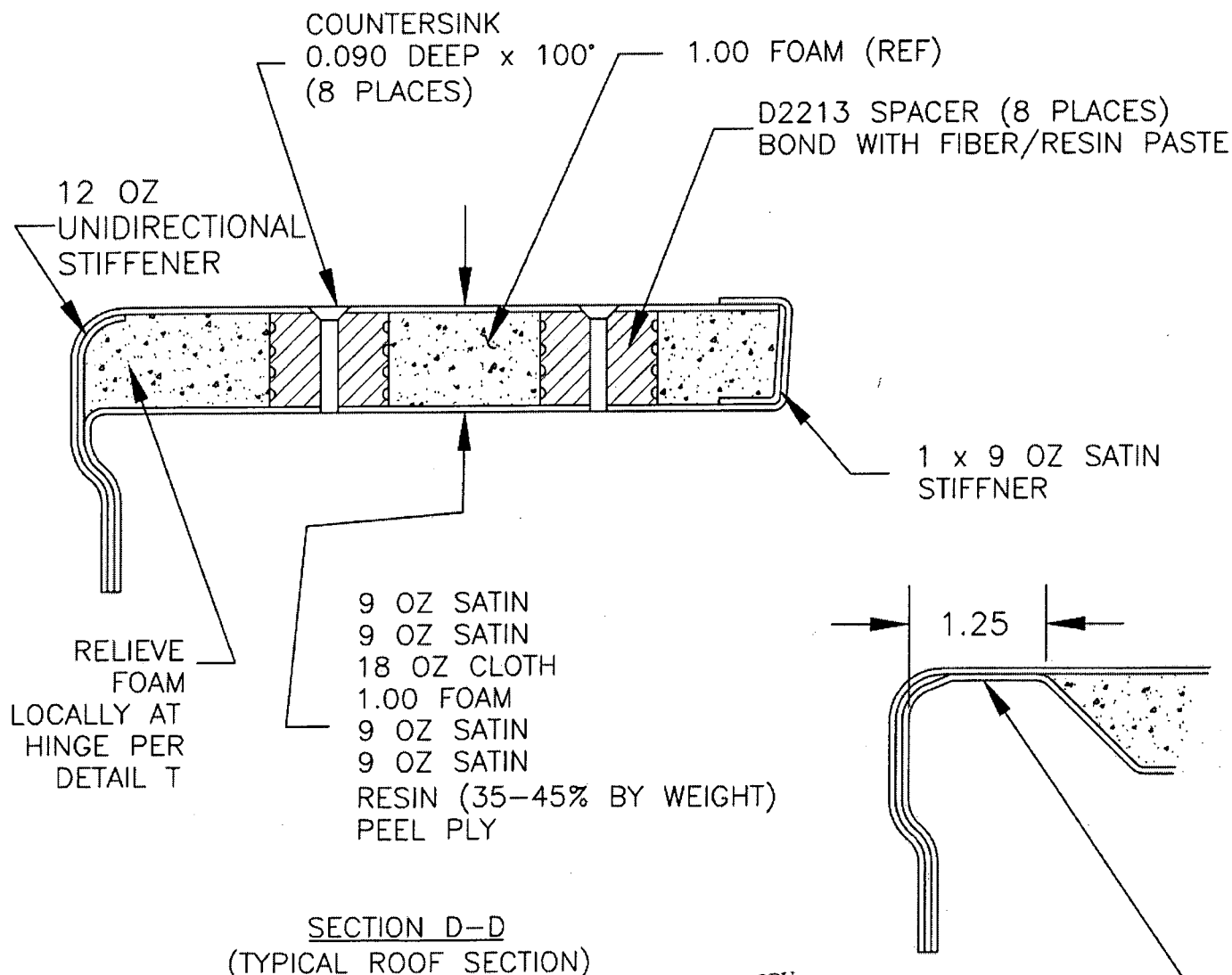
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CHECKED #	APPROVED C	DRAWING NO. D3188	REV. A SHEET 7 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

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03.04.22



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RELIEVE AS SHOWN
3" LONG CENTERED
ON HINGE
DETAIL T

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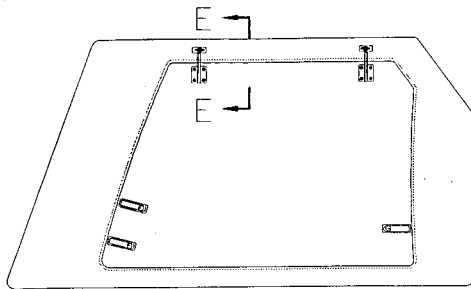


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

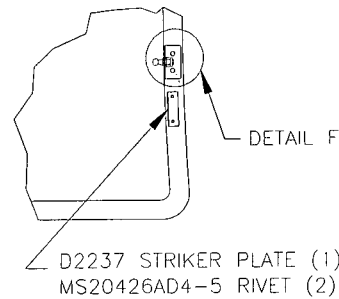


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

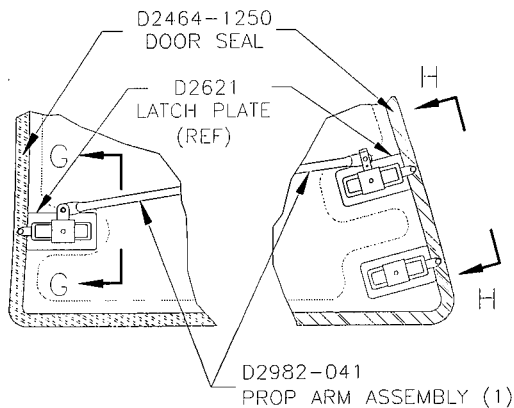
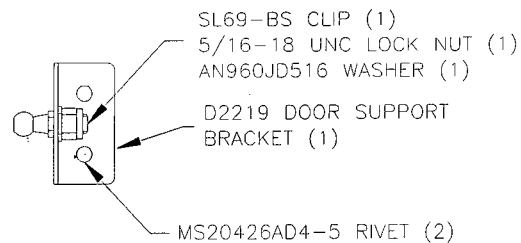


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted

MAY 07 2003

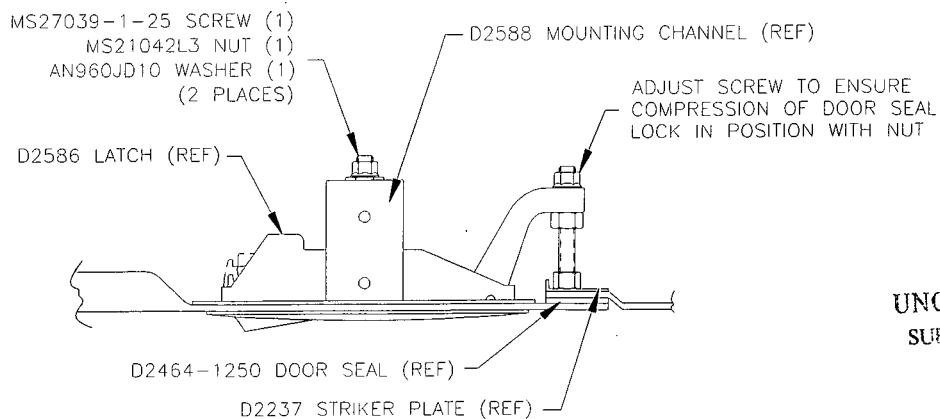
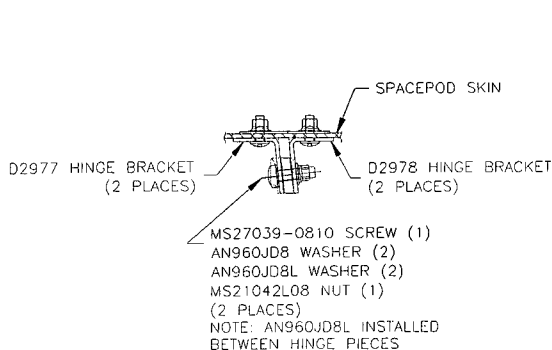


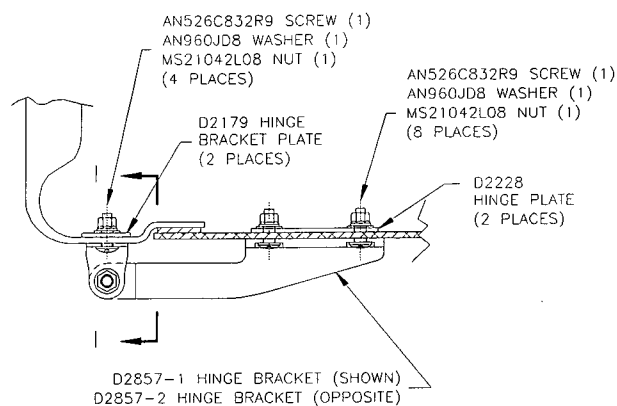
FIGURE 6. TYPICAL LATCH INSTALLATION

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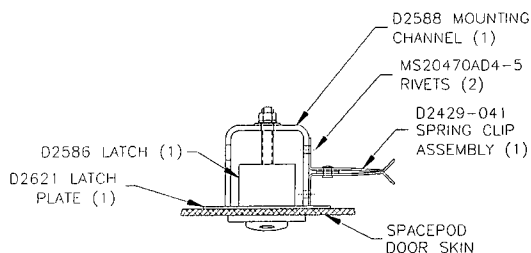
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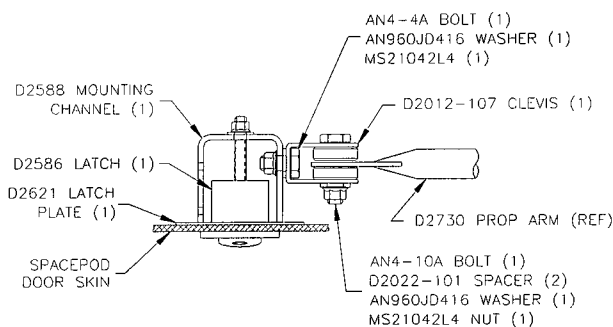
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

TC Accepted

MAY 07 2003

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25-00-00

Date: Monday, 3/6/2006 2:00:26 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD DOOR RH
Job Number :	26065B		
Estimate Number :	11099		
P.O. Number :		Part Number :	D31862
This Issue :	3/6/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3186 REV A1
First Issue :	3/6/2006	Project Number :	N/A
Previous Run :	26064B	Drawing Revision :	A1
		Material :	
Written By :		Due Date :	3/31/2006
Checked & Approved By :	<i>[Signature]</i> 06-03-06	Qty:	1 Um: Each
Comment :	Est Rev:A New Issue 05-11-29 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *745*Description: D3186-2 Door *u*SHIP LABEL D0600-146 *06-03-07*

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

2.0

D31862P

Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached. *06/7/06 (1)*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins. *06-07-06*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *C.A.*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 2:00:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 26065B

Part Number: D31862

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



CU 06-07-06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
A1	<i>GP</i> 04.11.04	New 4.5" WIDE UNIDIRECTIONAL	

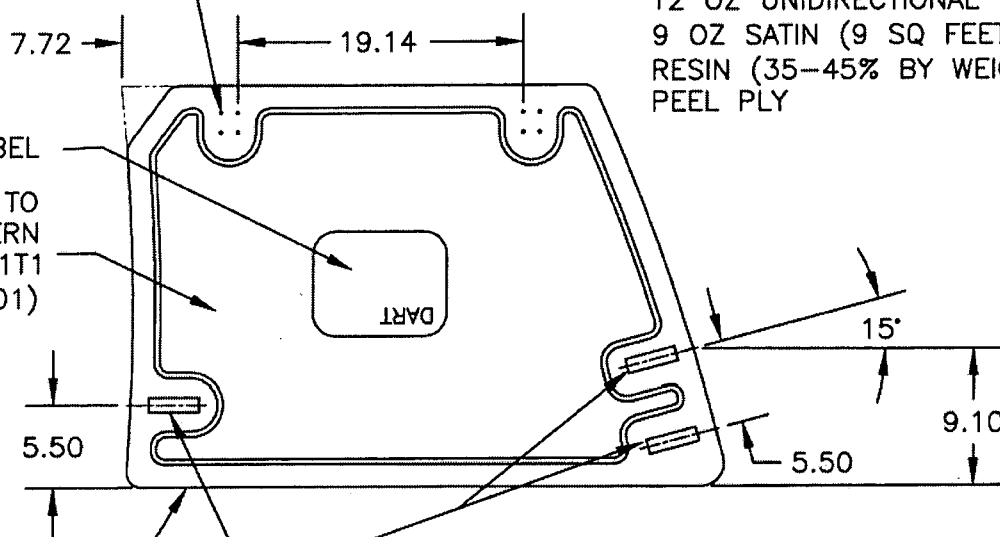
DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8005 (REFER
TO DETAIL B ON PAGE 3)

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

D0600-145 LABEL

ROUTER FOAM TO
ROUTER PATTERN
D3186-1T1
(P/N D3186-101)



12 OZ UNIDIRECTIONAL
4.5" WIDE 5" WIDE ALONG
OUTSIDE EDGE

CUT 3 PLACES AS SHOWN IN DETAIL A
ON PAGE 3

RELEASED
#03.04.22

D3186-1

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006.4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

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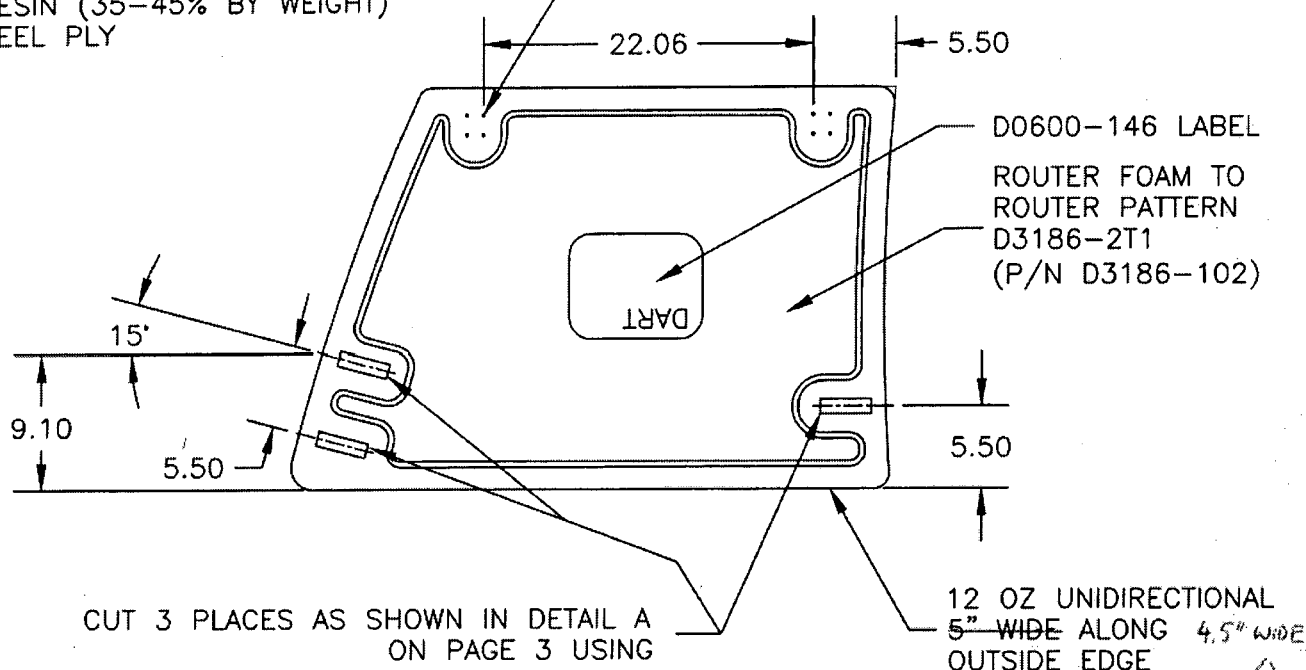


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CHECKED #	APPROVED #	DRAWING NO. D3186	REV. A SHEET 2 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8006 (REFER
TO DETAIL B ON PAGE 3)



RELEASED
#030422

D3186-2

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
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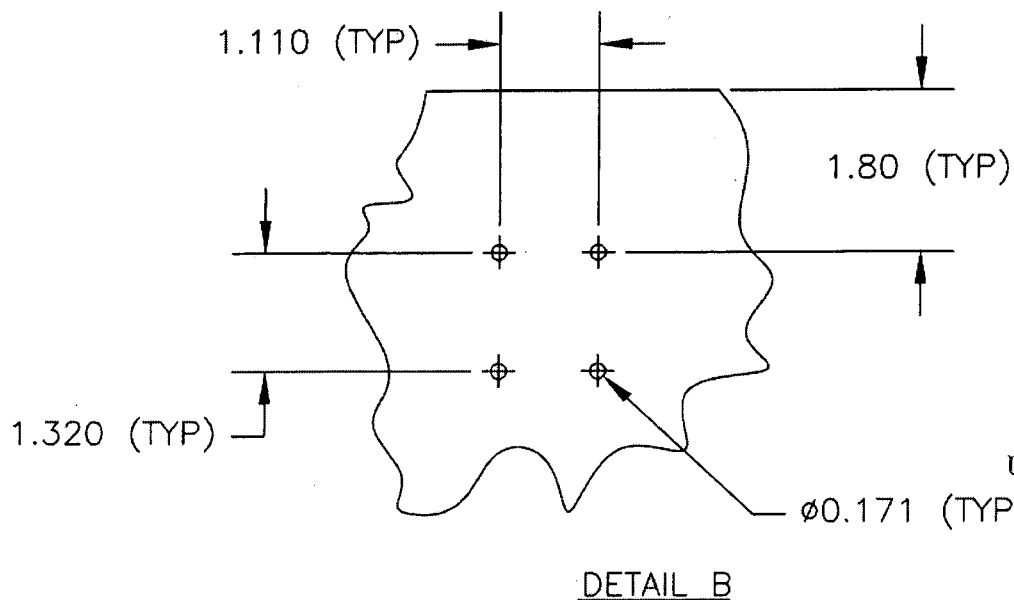
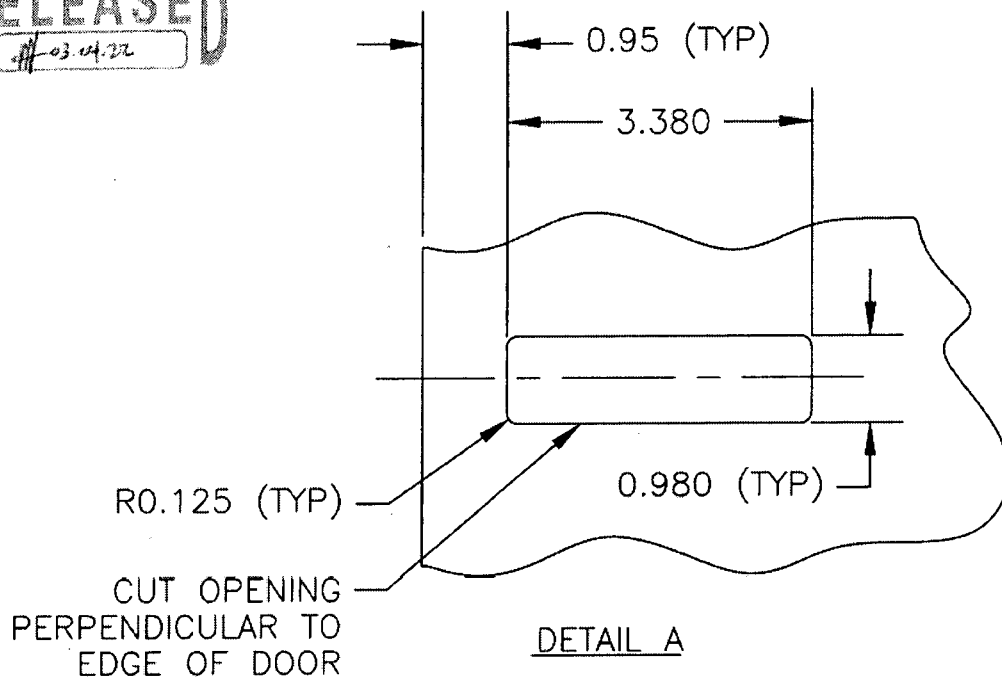
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2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	10680
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
03/07/06	07/03/06	4469	Linda Lacelle		PO00000745		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0020	D3188-2 Spacepod Body RH B26065 ✓ B26065 JOB: 33759 QTÉ: 1			
1	0	1	DKC134-0018	D3186-2 Spacepod Door RH B26065 ✓ B26065 JOB: 33756 QTÉ: 1			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357

Feuille de Procédé

Client : DART Dart Aerospace Ltd.	Nom Dessin : SPACEPOD DOOR
Numéro Job : 33756	Numéro Article : DKC134-0018
Numéro Soumission : 1713	Numéro Dessin : D3186
Numéro B.A. :	Projet Numéro : DKC134
Cette fois : 2006-06-13 No. B.V. :	Révision dessin : A1
Prsht Rev. : NC	Matériel : Fibre 7781 et Résine 411-350
Prem. fois : - - Type :	Date Dûe : 2006-04-28 Qté: 1 Udm: UNITE
Job précédente : 33752	



Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Dart Aerospace : D3186-2
N° Delastek Composites DKC-134-0018
N° de Projet Delastek: DK-362
Process Sheet Rev.: 06

B 26065

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 13-06-06 Heure Début: 10:15 Heure Fin: 12:40 Sceau:

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 33756Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0018

Numéro Job:



Séq.: Machine ou Opération:

Description :

7.0 AAC0326

9.7 oz 7781 Weave "S" glass #FG-778150-125Y

Commentair Qty.: 4.5 VERGE(s)/Unit Total: 4.5 VERGE(s)

9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-5456-1

8.0 AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-4734-1

9.0 AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

10.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 13-06-99 Heure Début: 12:30 Heure Fin: 13:00 Sceau:

11.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)

Catalyst N° DDM-9 N° de Lot: 4292

12.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-5380-1

13.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs







PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 13-06-99 Heure Début: 13:00 Heure Fin: 13:10 Sceau:

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SPACEPOD DOOR	
Numéro Job: 33756		Numéro Article: DKC134-0018	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
14.0	LAMINAGE.	LAMINAGE PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs FAIRE LE LAMINAGE DES TISSUS À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz. Recommencer l'opération pour le deuxième pli. Date: <u>13-06-00</u> Heure Début: <u>13:00</u> Heure Fin: <u>13:30</u> Sceau: <u>YL</u>			
15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs EFFECTUER LA POCHE A VIDE Faire la poche à vide en appliquant les composantes dans l'ordre suivant: 1- Tissu à délaminer, 2- Film perforé P-3, 3- Feutre de drainage 4- Sac à vide Stretchlon 200 Laisser sécher pendant 4 heures minimum. Date: <u>13-06-00</u> Heure Début: <u>13:30</u> Heure Fin: <u>13:40</u> Sceau:  Curing Début: <u>13:40</u> Curing Fin: <u>Suséquent le lendemain</u>			
16.0	AAC0275	Catalyst N° DDM-9	
Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s) Catalyst N° DDM-9 N° de Lot: <u>4292</u>			
17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-5380-1</u>			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 33756Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

18.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heure.

Date: 13-06-00 Heure Début: 13:40 Heure Fin: 13:55 Sceau:

19.0

AAC0452

Polybond B46F

Commentaire Qty.: 0.082 KIT(s)/Unit Total: 0.082 KIT(s)

Polybond B46F

N° de Lot: 1-5448-1

20.0

DKC134-0025

Foam Core N° D3186-102 (Porte D3186-2)

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2)

N° de Lot: 1-5313-1

21.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0024 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 14-06 Heure Début: _____ Heure Fin: _____ Sceau:

22.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

14-06

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 33756

Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond

Date: 15 Heure Début: _____ Heure Fin: _____ Sceau: [Signature]Curing Début: 10.00 Curing Fin: 12.00

23.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 4292

24.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-5628-2.

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 15 Heure Début: _____ Heure Fin: _____ Sceau: [Signature]

26.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 15 Heure Début: _____ Heure Fin: _____ Sceau: [Signature] S.V.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 33756Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE

**Commentaire** Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 15 Heure Début: _____ Heure Fin: _____ Sceau: S.V.

Curing Début: _____ Curing Fin: _____

28.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART

**Commentaire** Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 16 Heure Début: _____ Heure Fin: _____ Sceau: S.V.

29.0

TRIMAGE 3

TRIMAGE COMPOSITES DART

**Commentaire** Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer la pièce l'aide du gabarit de trimage prévu à cet effet.

Perçer les " Latch " et les trous de pentures selon le dessin N° D3186

Date: A Heure Début: _____ Heure Fin: _____ Sceau: S.V.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 33756Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

30.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)
Dupont Primer N° 1104S

N° de Lot: 1-5390-1

31.0

AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)
Dupont Activator N° 7975S

N° de Lot: 1-5390-3

32.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)
Dupont Reducer N° 12375S

N° de Lot: 1-5535-3

33.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Appliquer une première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.

Application primer

Laisser sécher pendant 3 heures.

Date: 26/06/06

Heure Début:

Heure Fin:

Sceau:



35.0

FINITION 3

FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs
FINITION PIÈCE DART

Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 33756

Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

36.0

AAC0450

Label N°D0600-146

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Label N°D0600-146

N° de Lot: N/A

37.0

AAC0444

Surface Veil

Commentair Qty.: 0.08 VERGE(s)/Unit Total : 0.08 VERGE(s)

Surface Veil

N° de Lot: 2817

38.0

AAC0501

Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total : 0.015 GALLON(s)

Résine Mia-Poxy

N° de Lot: 1-5258-1

39.0

AAC0502

Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total : 0.030 PINTE(s)

Durcisseur 95 Pour Résine Mia-Poxy

N° de Lot: 1-5258-2

40.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Hrs Total Run : 15.0000Hrs

FABRICATION GÉNÉRALE DART

Coller le Label N° 0600-146 selon les séquences suivantes:

1 Surface Veil

2- Label

3- Surface Veil

À l'aide de la résine Mia-Poxy selon le dessin D3186.

Laisser sécher pendant 6 heures.

Date: 27/06/06

Heure Début: _____

Heure Fin: _____

Sceau: _____



41.0

AC0058

Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-5351-1

42.0

AC0059

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

43.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 33756

Numéro Article: DKC134-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description:

Date: 28/06/06

Heure Début:

Heure Fin:

Sceau:

31

44.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-5390-1

45.0

AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)

Dupont Activator N° 7975S

N° de Lot: 1-5390-3

46.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: 1-5395-3

47.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

48.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs

APPLICATION DE PRIMER

Masquer le label.

Appliquer une deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G.

Application de primer.

Date: 28/06/06

Heure Début:

Heure Fin:

Sceau:

31

49.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

INSPECTION PIÈCE DART

Emballage

AT 1

3 juillet 06